

SHIP 28/08 - 31/08

# Work Order ID 51580

August 26, 2009 3:23:28 PM



Item ID: D3955-041  
Revision ID: A  
Item Name: Doubler Assembly

Accept



Setup Start  
Stop



Start Date: 8/27/09 Start Qty: 12.00  
Required Date: 8/31/09 Req'd Qty: 12.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: *[Signature]*  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3955	A								
100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet									
	6061								
	.063								
	Memo								
	1-Cut as per Dwg D3955-1								
	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC		0.00							
Quality Control	Memo								

12  
IB 9-8-27

IB 9-8-27

(12)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 26, 2009 3:23:28 PM

Page 1

Work Order ID: 51580

Parent Item: D3955-041RevA

Parent Item Name: Doubler Assembly


Comments:

Start Date: 8/27/09

Required Date: 8/31/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	119.0671	4.4880			
												
6061-T6 .063 Sheet												

B 9-8-27

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT

119.0671211

109463

-0.0223

110551

119.089421

MS21086L3

Purchased

No

180

Each

43.0000

12.0000



Nut Plate

110551

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

43

112219 ✓

43

MS20427M3-3

Purchased

No

180

Each

400.0000

24.0000



Rivet

12X  
M112219 38X

M-L 09/08/28

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

400

110022

115

111819 ✓

285

M111819 24X

M-L 09/08/28

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	51580
<b>Description:</b> Doubled Assembly		<b>Part Number:</b>	D3955-041
<b>Inspection Dwg:</b> D3955-1 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

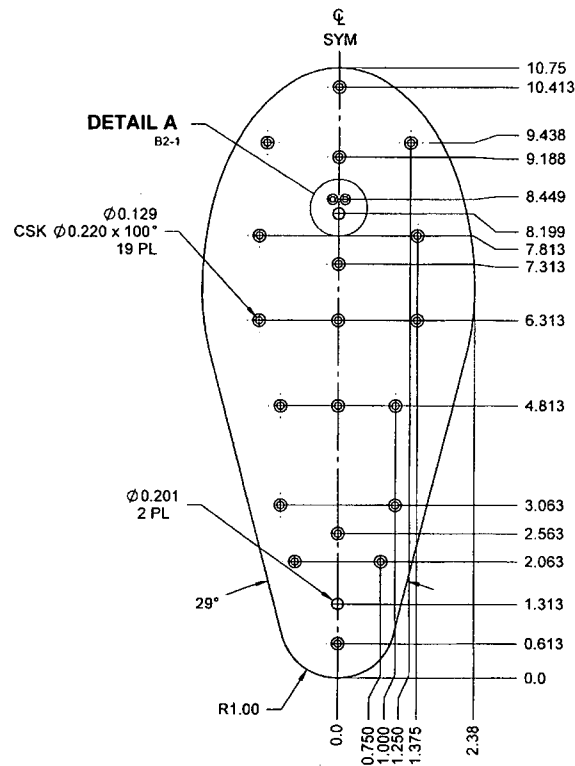
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	± .004 - .001	.102	X			
Ø .129	± .005 - .001	.133	X			
Ø .201	± .005 - .001	.204	X			
.750	± .010	.750	✓			
1.000	± .010	1.001	✓			
1.250	± .010	1.252	X			
1.375	± .010	1.376	X			
2.38	± .030	2.378	X			
.613	± .010	.614	X			
1.313	± .010	1.311	X			
2.063	± .010	2.056	X			
2.563	± .010	2.558	X			
3.063	± .010	3.065	X			
4.813	± .010	4.811	X			
6.313	± .010	6.315	X			
7.313	± .010	7.312	X			
7.813	± .010	7.810	X			
8.199	± .010	8.199	✓			
8.449	± .010	8.444	X			
9.188	± .010	9.190	X			
9.438	± .010	9.442	X			
10.413	± .010	10.414	X			
10.75	± .030	10.745	X			

<b>Measured by:</b> LB	<b>Audited by:</b> S	<b>Prototype Approval:</b> 1/
<b>Date:</b> 9-8-27	<b>Date:</b> 09/08/27	<b>Date:</b> 1/8

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



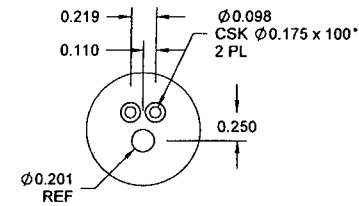
0.063  
REF

INS  
MS  
MS

CSK SIDE

D3955-1  
DOUBLER

INSTALL  
MS21086L3 NUT PLATE  
MS20427M3-3 RIVET, 2 PL



**DETAIL A** D7-1  
**SCALE 2X**

RELEASED  
09/07/22 NND

**D3955-041 DOUBLER ASSEMBLY**

D3955-1 DOUBLER

**D3955-1 NOTES:**  
 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.25 lbs

A	NEW ISSUE		RF	09.07.21
REV.		DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3955</b>  <b>SKIDTUBE TUNING KIT</b>		
DRAWN	RF			
CHECKED				REV. A
MFG. APPR.				SHEET 1 OF 5
APPROVED				SCALE
DE APPR.				NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

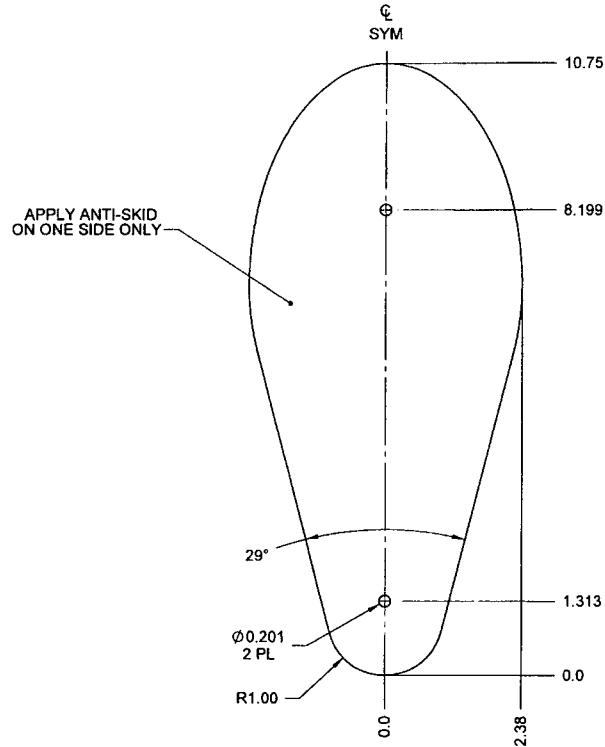
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D

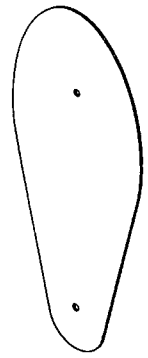
C

B

A



0.060 REF



D

C

B

A

**D3955-3 COVER PLATE**

51580

**RELEASED**  
09/15/22

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs

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MFG. APPR.		D3955	SHEET 2 OF 5
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8 7 6 5 4 3 2 1



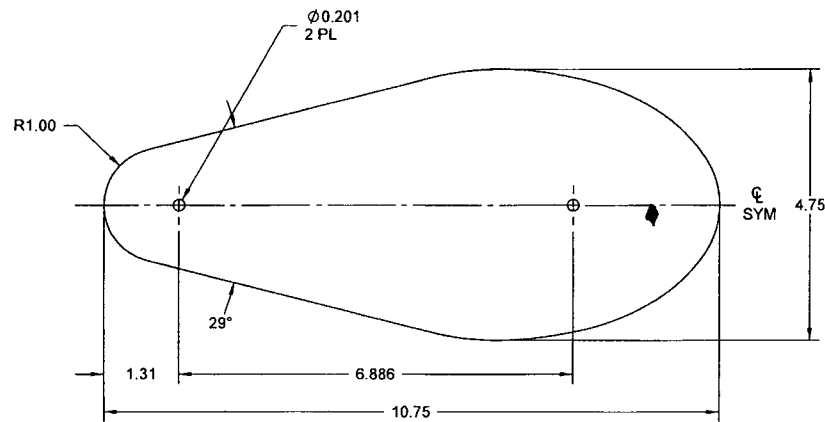
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3955-X PLATE**

General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'TGA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

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09/07/21

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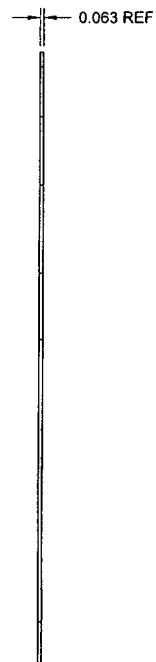
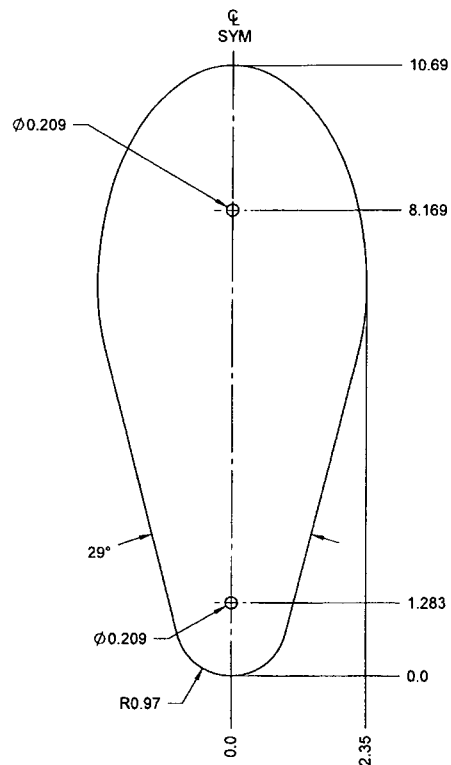
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3955-21 GASKET**

**D3955-21 NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER  
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

51580  
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09/07/21

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MFG. APPR.		D3955	SHEET 4 OF 5
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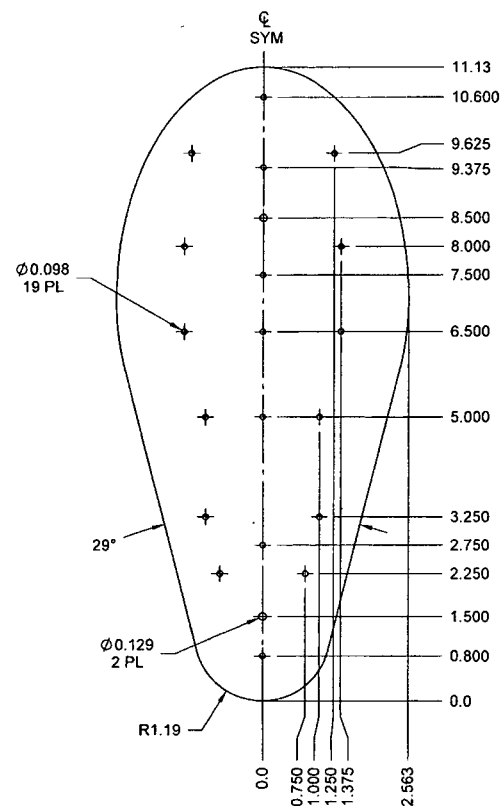
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**NOTE:** Date & initial all entries



0.040 REF



# **D3955-23 TEMPLATE**

## **NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

**RELEASED**  
01/17/21 MB

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 5 OF 5
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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